

This model was tested with **PLA material**.

To avoid printing problems, we recommend the following settings:

Extruder

Nozzle Diameter: 0.4 mm

Extrusion Multiplier: 0.97

Extrusion Width: Auto

Retraction Distance: 5.00 mm

Extra Restart Distance: 0.00 mm

Retraction Vertical Lift: 0.08 mm

Retraction Speed: 5400.0 mm/min

Wipe Distance: 5.00 mm

Layer

Primary Layer Height: 0.1 mm

Top Solid Layers: 8

Bottom Solid Layers: 5

Outline/Perimeter Shells: 2

Outline Direction: Inside-Out

First Layer Height: 90%

First Layer Width: 100%

First Layer Speed: 20%

Additions

Use Skirt/Brim: Check

Skirt Layers: 1

Skirt Offset from Part: 6.00 mm

Skirt Outlines: 5

Infill

Internal Fill Pattern: Fast Honeycomb

External Fill Pattern: Rectilinear

Interior Fill Percentage: 10%

Outline Overlap: 22%

Infill Extrusion Width: 100%

Minimum Infill Length: 5.00 mm

Combine Infill Every: 1 layers

External Infill Angle Offsets: 45/-45 deg

Support

Generate Support Material: Check

Support Infill Percentage: 15%

Extra Inflation Distance: 1.00 mm

Support Base Layers: 0

Combine Support Every: 1 layers

Dense Support Layers: 0

Dense Infill Percentage: 70%

Support Type: Normal

Support Pillar Resolution: 5.00 mm

Max Overhang Angle: 60 deg

Horizontal Offset From Part: 0.50 mm

Upper Vertical Separation Layers: 1

Lower Vertical Separation Layers: 1

Support Infill Angles: 45 deg

Temperature

Extruder 1 Temperature: 210

Heated Bed: 60

Cooling

Increase fan speed for layers below: 45.0 sec

Maximum Cooling fan speed: 50%

Bridging fan speed override: 100%

Speeds

Default Printing Speed: 4800.0 mm/min

Outline Underspeed: 50%

Solid Infill Underspeed: 80%

Support Structure Underspeed: 80%

X/Y Axis Movement Speed: 10800.0 mm/min

Z Axis Movement Speed: 1002.0 mm/min

Adjust printing speed for layers below: 15.0 sec

Allow speed reduction down to: 20%

Other

Unsupported area threshold: 20.0 sq mm

Extra inflation distance 0.00 mm
Bridging extrusion multiplier: 100%
Bridging speed multiplier: 100%

Advanced

External Thin Wall Type: Perimeters Only
Internal Thin Wall Type: Allow gap fill
Allowed perimeter overlap: 10%

Minimum Extrusion Length: 1.00 mm
Minimum Printing Width: 50%
Maximum Printing Width: 200%
Endpoint Extension Distance: 0.2 mm

Only retract when crossing open spaces: Check
Minimum travel for retraction: 2.00 mm
Perform retraction during wipe movement: Check
Only wipe extruder for outer-most perimeters: Check

Non-manifold segments: Heal